

Nov. 23

Work Order ID 76326

\*76326\*

Page 1

November-09-11 8:33:42 AM

Item ID: D4018-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Short Basket Lid Assembly (350 )  
 Start Date: 09/11/2011 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 23/11/2011 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/09 Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4018	C

100 Weld per dwg A/R S.S. rod Batch: M115778 0.00  
 \*100\* Large Fab  
 Memo 0.00

Large Fab  
 1- assemble ribs , weld as per dwg D4018 using DT9607B  
 2- weld hinge (3) and Mounting brackets as per dwg D4018  
 \*\*\*inspect before welding mesh\*\*\*  
 3- tack weld mesh on basket as per dwg D4018  
 \*\*\*make sure to place mesh correctly on lid, check with label plate before tacking mesh\*\*\*

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00  
 \*110\* QC Memo 0.00

Quality Control

11/11/17 (1x)

11.11.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130 <b>*130*</b> Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3  Memo *** mask sides of hinge prior to powdercoat*** Start Time: <u>10:45</u> Oven Temperature: <u>50 F</u> Finish Time: <u>11:32</u>	0.00 0.00							
140 <b>*140*</b> HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <u>117338</u>  Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg  Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00 0.00							

*Handwritten signature: NPM 11/11/21*

*Handwritten signature: 1 BK 11-11-21*

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 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
76326. 7032-041.									
160	Identify as per dwg & Stock Location: <del>76326</del>	0.00							
<b>*160*</b>									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
<b>*170*</b>									
QC	Memo	0.00							
Quality Control									

11/11/22   
 11-11-22  
 MF  
 11-11-22

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# Picklist Print

November-09-11 8:33:47 AM

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Work Order ID: 76326

\*76326\*

Parent Item: D4018-041

\*D4018-041\*

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1 *D4018-1* Rib		Manufactured	No			100	Each	5.0000	2	2			
** B74273 → (2x) 11/11/16													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				72545		5							
✓ D4018-3 *D4018-3* Rib		Manufactured	No			100	Each	10.0000	2	2			
** 11/11/16													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				72546		2							
				WA005		8							
				68479		2							
				73032		6							
✓ D4016-3 *D4016-3* Hinge Half, Lid		Manufactured	No			100	Each	31.0000	3	3			
** 11/11/16													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		30							
				73630		12							
				74909		18							
				WA005		1							
				71941		1							

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4018-5	Manufactured	No	100	Each	31.0000	6	6	**	11/11/16
*D4018-5*									
Rib									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA	18					
			74917	18					
			WA005	13					
			74636	13					
✓ D4035-041	Manufactured	No	100	Each	0.0000	1	1	**	11/11/16
*D4035-041*									
Lid Rib Assembly, Fwd (350 Basket)									
✓ D4035-043	Manufactured	No	100	Each	2.0000	1	1	**	11/11/16
*D4035-043*									
Lid Rib Assembly, Aft (350 Basket)									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA006	2					
			73628	2					
✓ D2581	Manufactured	No	100	Each	23.0000	2	2	**	11/11/16
*D2581*									
Mounting Bracket									
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
			WA	23					
			69739	2					
			70766	2					
			73762	19					
✓ D4020-7	Manufactured	No	100	Each	0.0000	1	1	**	11/11/17
*D4020-7*									
Mesh (350 Basket Short, Lid)									

W/O:		WORK ORDER CHANGES					
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Parent Item: D4018-041

**\*D4018-041\***

Parent Item Name: Short Basket Lid Assembly (350 )

Start Date: 09/11/2011

Required Date: 23/11/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4021-3

Manufactured No

100

Each

4.0000

1

1

**\*D4021-3\***

Data Plate

\*\*

*ly 11/11/16*

Location

Loc Qty

Loc Code

WA

4

73632

4

D2728-3

Manufactured No

140

Each

0.0000

1

**\*D2728-3\***

Dart Logo label

\*\*

*(X)*

*115050.*

*1 BR. 11-11-21.*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

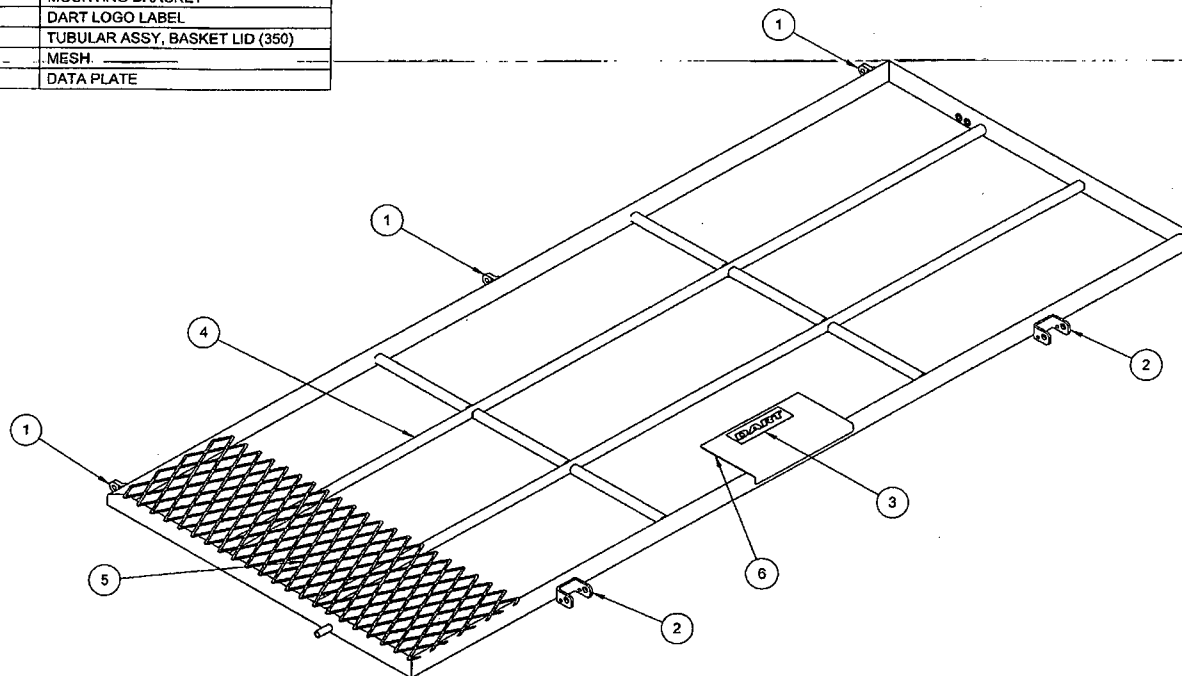
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ITEM	QTY	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 76326 M.C.J  
1111/09

**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
10.08.12  
ECN 10-546

C	REMOVED D4088-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4088-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (B4-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	J		
CHECKED	SC		
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4018** REV. C  
SHEET 1 OF 4

TITLE **SHORT BASKET LID ASSY (350)** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

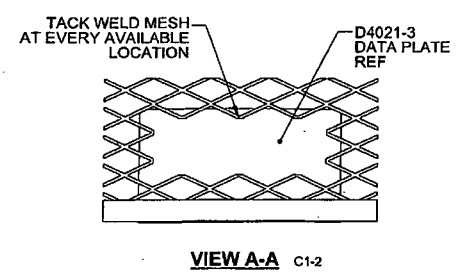
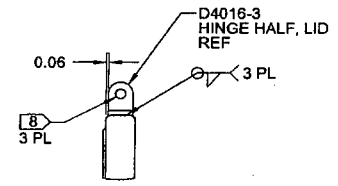
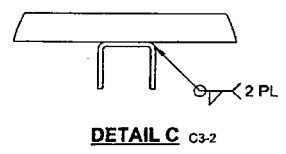
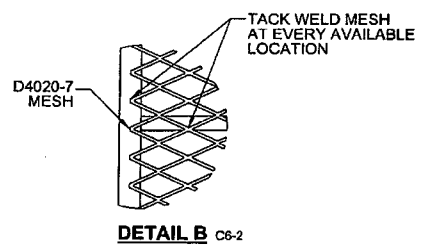
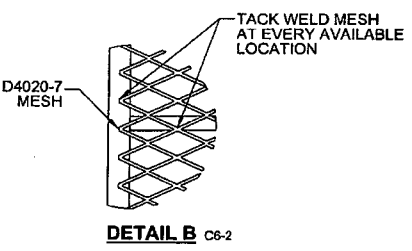
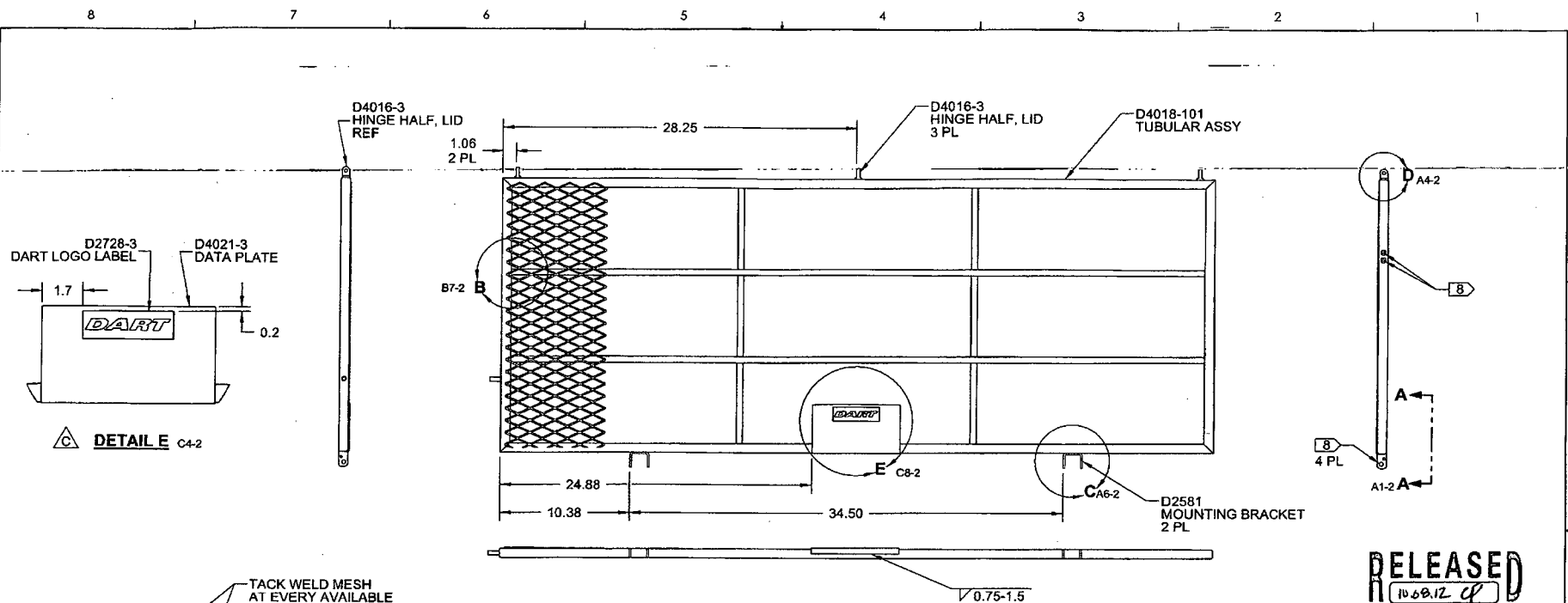
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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76326



RELEASED  
10.08.12

**D4018-041 SHORT BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 14.5 lbs APPROX
  - 8) MASK HOLES PRIOR TO FINISHING
  - 9) WELD PER DART QSI 004

DESIGN	ALS	<b>DART AEROSPACE LTD</b>	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	AND	D4018	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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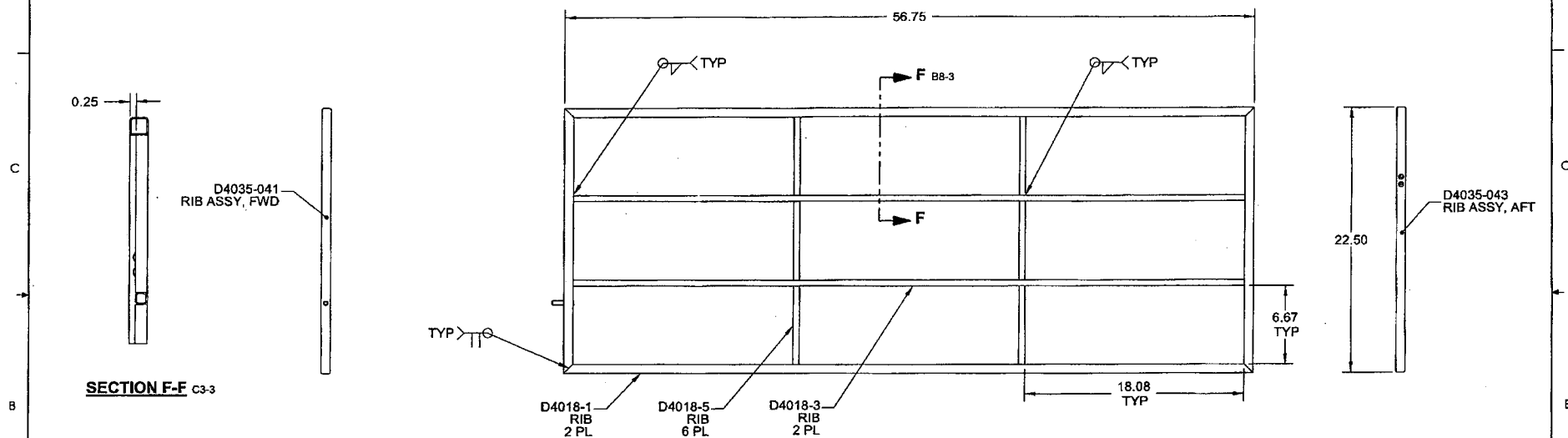
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ITEM	QTY	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED  
10.08.05

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	MP	D4018	SHEET 3 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	MP	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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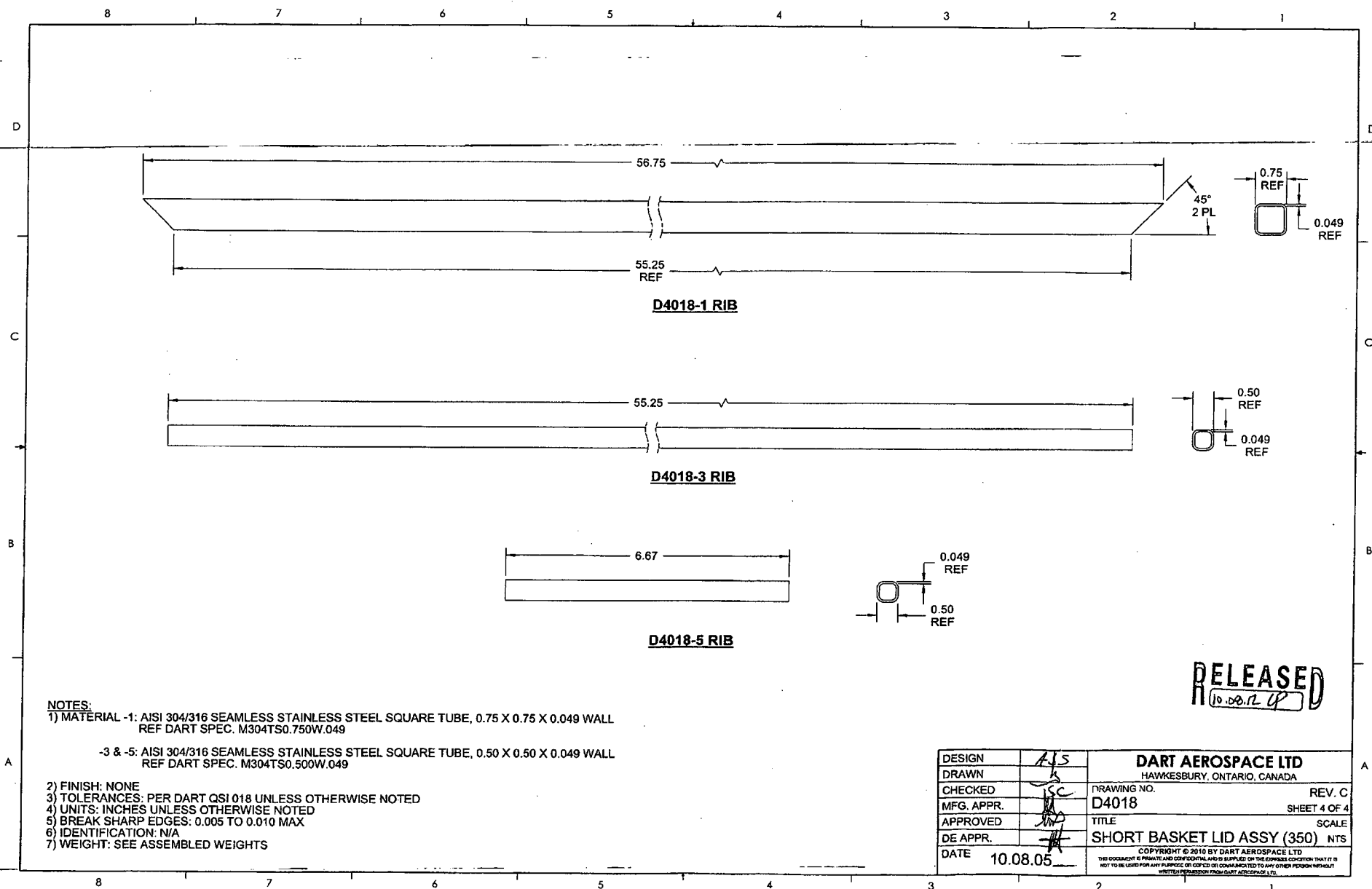
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